

assemble the unloaded components into the data storage device.

2. (Twice Amended) The apparatus of claim 1 wherein the carousel supports a plurality of stacks of components at spaced locations arranged about a center point and the apparatus comprises:

a motor coupled to the carousel base to rotationally position each stack of components for assembly.

3. (Twice Amended) The apparatus of claim 2 wherein the carousel coupling device comprises a vacuum source operably coupled to the rotatable carousel base to supply vacuum pressure in an engaged mode to secure the carousel to the carousel base and to release the vacuum pressure to remove the carousel.

4. (Twice Amended) The apparatus of claim 2 further comprising an indexer coupled to the carousel base to align individual components from the plurality of stacks of components relative to the assembly arm.

5. (Twice Amended) The apparatus of claim 2 and including a carousel coupled to the carousel base and a plurality of elongated components container configured to contain a plurality of components and the carousel includes a plurality of latch assemblies to removably secure the plurality of containers at spaced locations about a rotation axis of the carousel base.

6. (Twice Amended) The apparatus of claim 1 wherein the apparatus includes a plurality of carousel bases rotationally coupled to the frame to support multiple component carousels and the driver moves the assembly arm between the multiple component carousels on the plurality of carousel bases to unload the multiple carousels on the plurality of carousel bases.

7. (Twice Amended) The apparatus of claim 1 and further comprising a disc carousel removably coupled to the carousel base adapted to support discs for assembly in a spindle motor of a data storage device.

B1  
8. (Twice Amended) The apparatus of claim 7 wherein the disc carousel includes a plurality of spaced latch assemblies about a circumference of the disc carousel to removably connect a plurality of disc containers storing a plurality of stacked discs to the disc carousel at concentric spaced locations.

---

Claim 9 remains unchanged.

---

10. (Twice Amended) The apparatus of claim 1 and further comprising a spacer carousel adapted to support spacers for assembly in a spindle motor of a data storage device.

11. (Twice Amended) The apparatus of claim 1 wherein the apparatus is adapted to assembly components of a disc stack supported by a spindle motor and further comprising:

B2  
a plurality of carousel bases including a carousel base adapted to support a component carousel for discs and a carousel base adapted to support a component carousel for spacers;

a plurality of assembly arms including an assembly arm coupled to the carousel base supporting the component carousel for discs to assemble the discs and an assembly arm coupled to the carousel base supporting the component carousel for spacers to assemble the spacers;

a plurality of drivers coupled to the plurality of assembly arms to move the assembly arms between the carousel bases and a loading station; and a controller coupled to the drivers of the assembly arm to coordinate operation of the plurality of assembly arms to alternately assemble discs and spacers.

B2 12. (Twice Amended) The apparatus of claim 11 wherein the component carousel for the discs includes a frame including a plurality of circumferentially spaced latch assemblies to removably couple a plurality of disc containers to the carousel.

13. (Twice Amended) The apparatus of claim 12 wherein the disc containers house a disc stack including a plurality of coaxially aligned discs and further comprises an indexer to incrementally position the carousel base removably supporting the carousel for discsto sequentially unload individual discs in the disc stack.

14. (Twice Amended) The apparatus of claim 11 wherein the component carousel for spacers includes a base including a plurality of spacer posts arranged about a center point and sized to support a plurality of stacked spacers and including a motor coupled to the carousel base to move the carousel to align sequential stacks of spacers for assembly.

15. (Twice Amended) The apparatus of claim 14 further comprising an index rod operably coupled to the component carousel for spacers to push the spacers towards an extended end of the posts for assembly.

---

B3 21. (Amended) An assembly apparatus comprising:

B3 an assembly arm and assembly arm driver operably coupled to the assembly arm to operate the assembly arm to unload components from the apparatus and load components in <sup>the</sup> ~~the~~ unassembled device; and means for intermittently stocking the apparatus with a supply of components for assembly by the assembly arms.

---

Please add new claims 22-26 as follows:

---

22. (New) The apparatus of claim 6 wherein the apparatus includes a detector and the assembly arm is coupled to a controller which is configured to shift operation of the assembly arm from one of the multiple carousels to another of the multiple carousels supported on the plurality of carousel bases.

23. (New) An assembly apparatus comprising:

- B4
- a frame;
  - a plurality of carousel bases rotationally coupled to the frame;
  - an assembly arm movably coupled to the frame;
  - an assembly arm driver coupled to the assembly arm to operate the assembly arm to unload components from carousels coupled to the carousel bases; and
  - a controller operably coupled to the assembly arm and configured to sequentially operate the assembly arm between the plurality of carousel bases.

24. (New) The apparatus of claim 23 wherein the plurality of carousel bases support disc carousels and further comprising a plurality of disc unloaders coupled to the plurality of carousel bases and the assembly arm is operably between the plurality of disc unloaders and the plurality of carousel bases are coupled to an elevator to position sequential stacked discs on the disc carousels relative to the plurality of disc unloaders.

B4 25. (New) The apparatus of claim 24 wherein the disc carousels removably support a plurality of disc containers including a plurality of stacked discs.

26. (New) The apparatus of claim 25 wherein the disc containers are removably supported by a plurality of latch assemblies.

---